

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021711**Date Inspected:** 21-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Hai Feng CWI QA Bao Qiam.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3007AT

Weld No: 006,008

Welder: 037705

WPS-B-T-2233-ESAB

Components; OBG 14E

PCMK: SEG3019S

Weld No: 021,026

Welder: 066733

WPS-B-T-2233-ESAB

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This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Hai Feng CWI QA Bao Qiam.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3007L

Weld No: 065,069

Welder: 068924

WPS-B-P-2213-TC-U4b-FMC-1

Components; OBG 14E

PCMK: SEG3007AU

Weld No: 034,038

Welder: 037743

Repair No. WR20075

WPS-345-SMAW-3G(3F)-FMC_Repair-1

Components; OBG 14E

PCMK: SA3358-001

Weld No: 020

Welder: 067610

WPS-B-P-2114-FCM-1

Components; OBG 14E

PCMK: SEG3019BC

Weld No: 006

Welder: 037932

WPS-B-P-2114-FCM-1

Components; OBG 14E

PCMK: SEG3019Z

Weld No: 011

Welder: 066418

Repair No. CWR2755

WPS-345-SMAW-2G(2F)-FMC_Repair-1

Components; OBG 14E

PCMK: SEG303019D-2

Weld No: 164,165

Welder: 064656

Repair No. WR20273

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WPS-345-SMAW-1G(1F)-FMC_Repair-1

Components; OBG 14E

PCMK: SEG3019L-1

Weld No: 076

Welder: 215553

Repair No. WR19769

WPS-345-SMAW-3G(3F)-FMC_Repair-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W

PCMK: DP3174-001

Weld No: 018

Welder: 066480, 037780

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14W

PCMK: SEG3020BB

Weld No: 041

Welder: 065038

Weld Repair No. CWR2752

WPS-345-SMAW-2G(2F)-FMC-Repair

Components; OBG 14W

PCMK: SEG3020X

Weld No: 006,007

Welder: 067764

WPS-B-P-2214-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W

PCMK: SEG3013R

Weld No: 020

Welder: 067876, 066421

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WPS-B-P-2132-ESAB

Components; OBG 14W

PCMK: SEG3020BB

Weld No: 115

Welder: 067949

WPS-B-T-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
